

Date: Tuesday, 10/23/2007 3:11:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: OUTLET WELDMENT (206)	
Job Number	: 35336				
Estimate Number	: 10473				
P.O. Number	: N/A		Part Number	: D2414	
This Issue	: 10/23/2007	S.O. No. : N/A	Drawing Number	: D2414 REV. A	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 26906		Material	: N/A	
Written By			Due Date	: 11/6/2007	
Checked & Approved By			Qty:	3	Um: Each
Comment	: Est: C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2292	Heater Tube 4"	
✓	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) x/sel Heater Tube 4" Qty Part Number Description Batch B35339 → 1 1 D2292 4" Ring B30600 → 2		PD 07-10-25
2.0	D2406	3" Heater Tube	
✓	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) 3" Heater Tube Qty Part Number Description Batch B27184 1 D2406 3" Tubing		PD 07-10-25
3.0	D2415	End Plate	
✓	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) End Plate Qty Part Number Description Batch B26918 1 D2415 End Plate		PD 07-10-25
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1 Weld D2414 Outlet Assembly as per Dwg D2414 and QSI 004.		PD 07-10-25(3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/12/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 35336		Part Number: D2414
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		<i>10/07/07 (3)</i>
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>Fd 07/10/29 (3)</i>
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT ALODINE		<i>C 07/10/29 (3) counter</i>
8.0	OUTSIDE SERV.15	OUTSIDE SERVICES - LF
Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: 4957 Red Anodize D2414 as per Dwg D2414 Possible Supplier: Anodizing TNM Paint Ensure Certificate of Conformity is attached		<i>C 07/11/01 (3)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of confromity is attached		<i>7-11-02 SCP (3x)</i>
10.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		<i>7-11-13 (3)</i>
11.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 169		<i>7-11-15 SP 3X</i>
12.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>10/07/11/16 (3)</i>
Job Completion		 <i>W 07/11/16</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						/	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

PREPARED B. Williams	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>PW</i>	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995	TITLE 206 OUTLET WELDMENT	SCALE

RELEASED
Apr. 6, 1995 BW

QTY	Part No.	Description
X	D2414	OUTLET WELDMENT ASSEMBLY
1	D2292	4" TUBING
1	D2406	3" TUBING
1	D2415	END PLATE

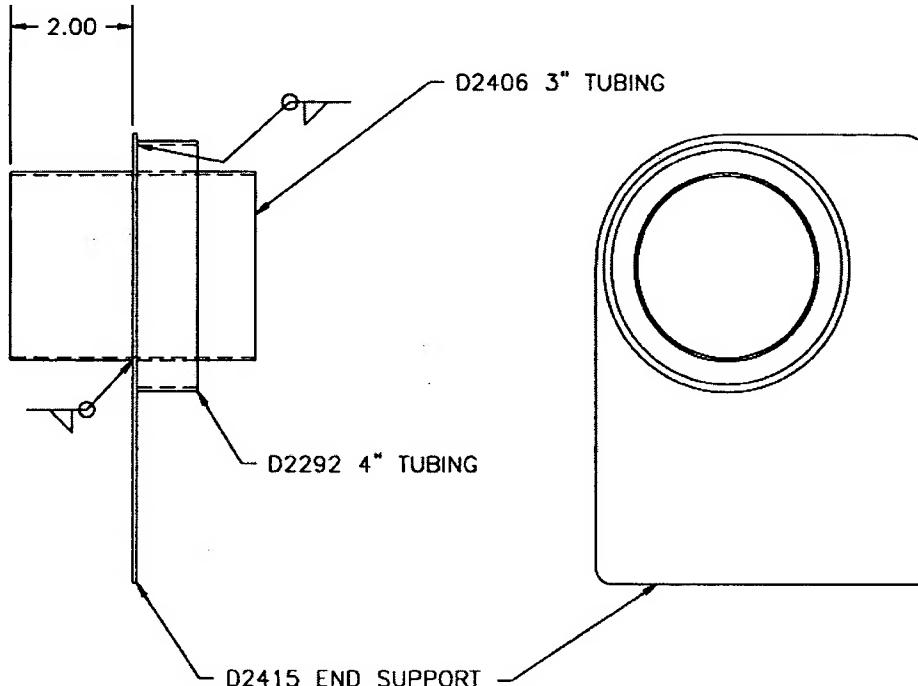
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *35336*

DART



PREPARED	DART AERO ACCESSORIES INC	
B. Williams	VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. A
CHECKED	APPROVED	SHEET 2 OF 2
B.W.	P.S.	SCALE
DATE	Apr. 6, 1995	206 OUTLET WELDMENT

RELEASED
960910 B.W.



FINISH: ANODIZE

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 35336

TNM**ANODISATION et PEINTURE TNM INC.****C. OF C**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 / AS9100 certified
 approuvé NADCAP approved

59970

09-Nov-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY , ONTARIO
 K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**PURCHASE ORDER/**
NO. DE COMMANDE:

04957



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	4	4	D2413B35335	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
3	3	3	D2414B35336	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
1	2	2	D2224B34970	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

ENT / CUSTOMER:

RT AEROSPACE LTD.

10 ABERDEEN STREET

WIKESBURY , ONTARIO

N1K7

PURCHASE ORDER/
NO. DE COMMANDE: 04957

CONDITIONS / TERMS:

NET 30 JOURS / NET 30 DAYS

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	4	4	D2413B35335	\$0.00	\$0.00
3	3	3	D2414B35336	\$0.00	\$0.00
1	2	2	D2224B34970	\$0.00	\$0.00
MINIMUM CHARGE					\$120.00
					SUB TOTAL: \$120.00
					TPS/GST: \$7.20
					TVQ/PST: \$0.00
					TOTAL AMOUNT DUE: \$127.20

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû à la valeur intrinséque de certaines responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

GLOBAL INM INC.
21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

PACKING
SLIP
59970
09-Nov-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY , ONTARIO
K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:** 04957

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION
1	2	2	D2224B34970
1	4	4	D2413B35335
3	3	3	D2414B35336

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.
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